

Work Order ID 161732

161732

Page 1

Tuesday, May 23, 2017 9:33:34 AM

Item ID: D2744 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cap
Start Date: 6/7/2017 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 6/16/2017 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: MAY 23 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2744	Rev C								
100	FLOW WATER JET	0.04							
100									
Waterjet	Memo	0.20							
FLOW CNC Waterjet	1-Cut as per Dwg D2744 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.10							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.20							
Quality Control									

DAS
14
9-89

DAS
14
9-89

DAS
38
9-89

MAY 29 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG001</u> <u>Memo</u> ***STOCK IN SKIDTUBE CELL*** LOCATION : LG001	0.00 0.10				<u>10x</u>	<u>DAS 26 9-89</u>		MAY 29 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release <u>Memo</u>	0.00 1.00							17/5/31 <u>df</u>

M
MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 23, 2017 9:33:33 AM

Page 1

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161732

Parent Item: D2744

D2744

Parent Item Name: Cap

Start Date: 6/7/2017

Required Date: 6/16/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C03.01.17Reformat; Dwg revisedKJ/RF
 IPP Rev:D Now on Waterjet 06-06-16 JLM
 IPP Rev:E As per Rev C 07-07-28 JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M5052H32S.080

Purchased

No

100

sf

42.8000

0.1823

1.918947

M5052H32S 080

**

5052-H32 .080 Sheet

SC 17/05/28

Location

Loc Qty

Loc Code

MAT022

42.8

m133121

10.8

m137263

32

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

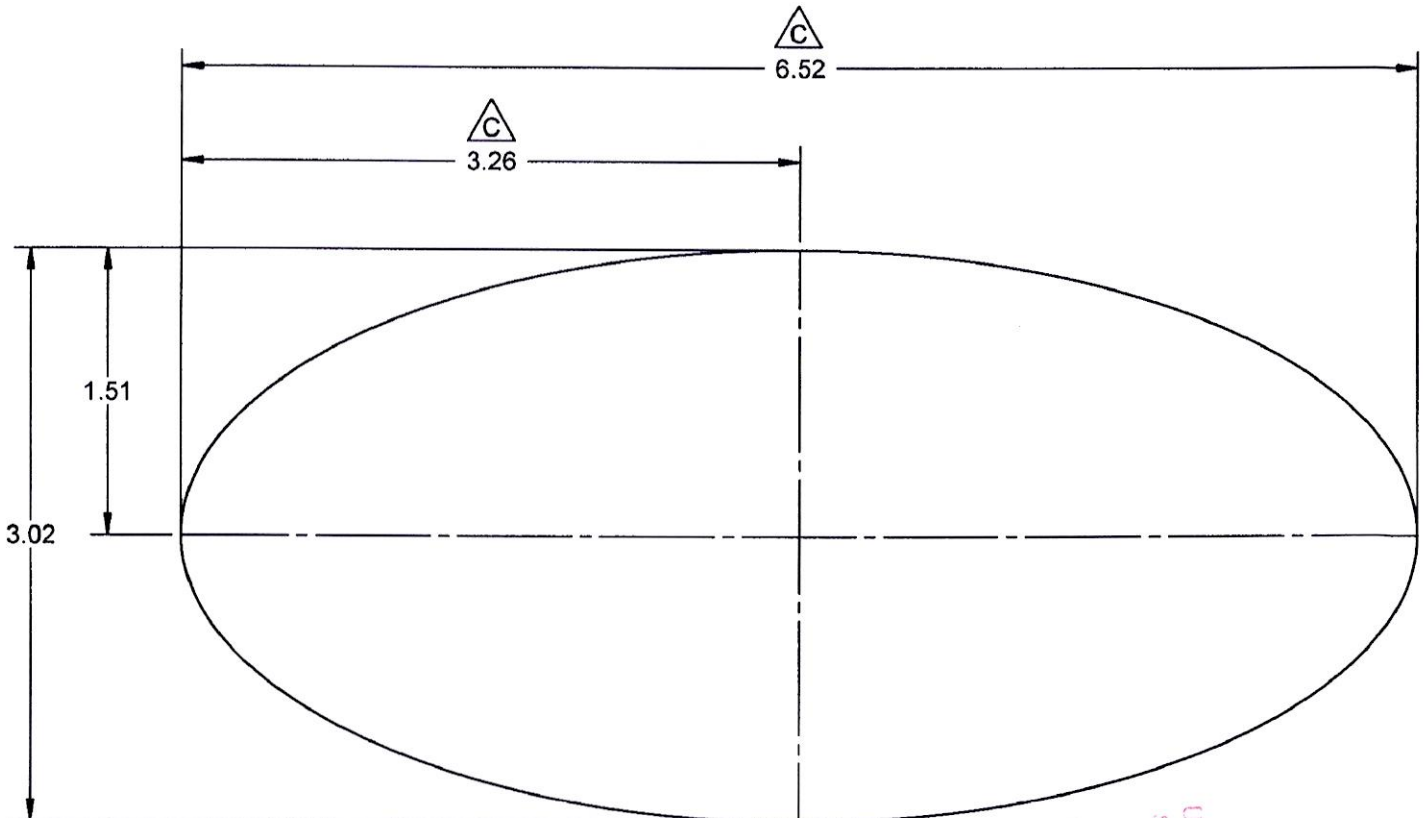
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER :																							



DESIGN #	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED J.H.	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02 #



D2744 CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161732
#5
1705-23

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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